

Date: Wednesday, 3/12/2008 1:41:52 PM  
User: Kim Johnston

## **Process Sheet**

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number	: 37854		
Estimate Number	: 10533		
P.O. Number	:	Part Number	: D2573
This Issue	: 3/12/2008	S.O. No.	: D2573 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Type	: MACHINED PARTS
Previous Run	: 37566	Drawing Revision	: E
Written By	:	Material	:
Checked & Approved By	: <u>DJP 08/03/12</u>	Due Date	: 4/4/2008
Comment	: Est: I As Per RevE 06-01-27 JLM	Qty:	8 Um: Each
Additional Product			
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
1.0	D6101007	7075-T7351 8.25X7.75X2.5	
Comment:	Qty.: 1.0000 Each(s)/Unit	Total : 8.0000 Each(s)	
	7075-T7351 8.25X7.75X2.5		
	Make from D6101-007 billet for D2573		
	Ensure that grain is along 7.75" length		
	Batch No: <u>B34875</u>		<u>DJP 08/03/14</u>
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
Comment:	HAAS CNC VERTICAL MACHINING #1		
	Program Batch No: <u>37854</u> Double check by: <u>DJP</u>		
	1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets		
	2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets		
	3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets		
	4-Deburr and remove all machining marks		
	5-Tumble to remove sharp edges.		
			<u>DJP 08/03/18</u>
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
Comment:	CONVENTIONAL MILLING MACHINE		
	Machine keyway as per dwg D2573 & D2574		<u>DJP 08/03/18</u>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
Comment:	INSPECT PARTS AS THEY COME OFF MACHINE		<u>DJP 08/03/18</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/12/2008 1:41:53 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 37854

Part Number: D2573

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

AS 08/03/24

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

AS 08-03-24 (X8)

7.0 POWDER COATING

POWDER COATING



M 107005

(S)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

AS 08-03-25

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



AS

08-03-25 (X8)

Comment: INSPECT POWDER COAT

PACKAGING RESOURCE #1

Identify and Stock

Location: ST 433

AS

08/03/25

(X8)

9.0 PACKAGING 1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 433

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AS 08/03/26

(X8)

Job Completion



AS 08/03/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37854
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.004	8.003	8.005	8.005		
F	0.490	0.510		.505	.502	.504	.504		
G	0.257	0.262		.260	.260	.260	.260		
H	0.375	0.380		.378	.378	.378	.378		
I	0.490	0.510		.501	.505	.504	.505		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.569	.571	.571	.571		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.368	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.499	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.133	.127	.126	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.255	.256	.256	.256		
S	0.115	0.135		.121	.124	.128	.127		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.228	3.226	3.228	3.230		
V	0.230	0.250		.239	.246	.243	.243		
W	0.115	0.135		.120	.134	.129	.128		
X	0.308	0.313		.309	.310	.311	.310		
Y	0.760	0.765		.761	.761	.760	.760		
Z	0.352	0.372		.365	.363	.367	.366		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.630	.632	.625	.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.248	.257	.253	.251		
AE	1.500	1.520		1.519	1.510	1.515	1.512		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.249	.256	.255	.254		
AI	2.000	2.020		2.008	2.000	2.005	2.003		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by:	Amf / SA	Audited by:	JP
Date:	08/03/18	Date:	08/03/24

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	JP

DART AEROSPACE LTD

Work Order:

37854

Description: Saddle, Aft Outboard

Part Number:

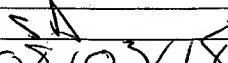
D2573

Inspection Dwg: D2573 Rev. E

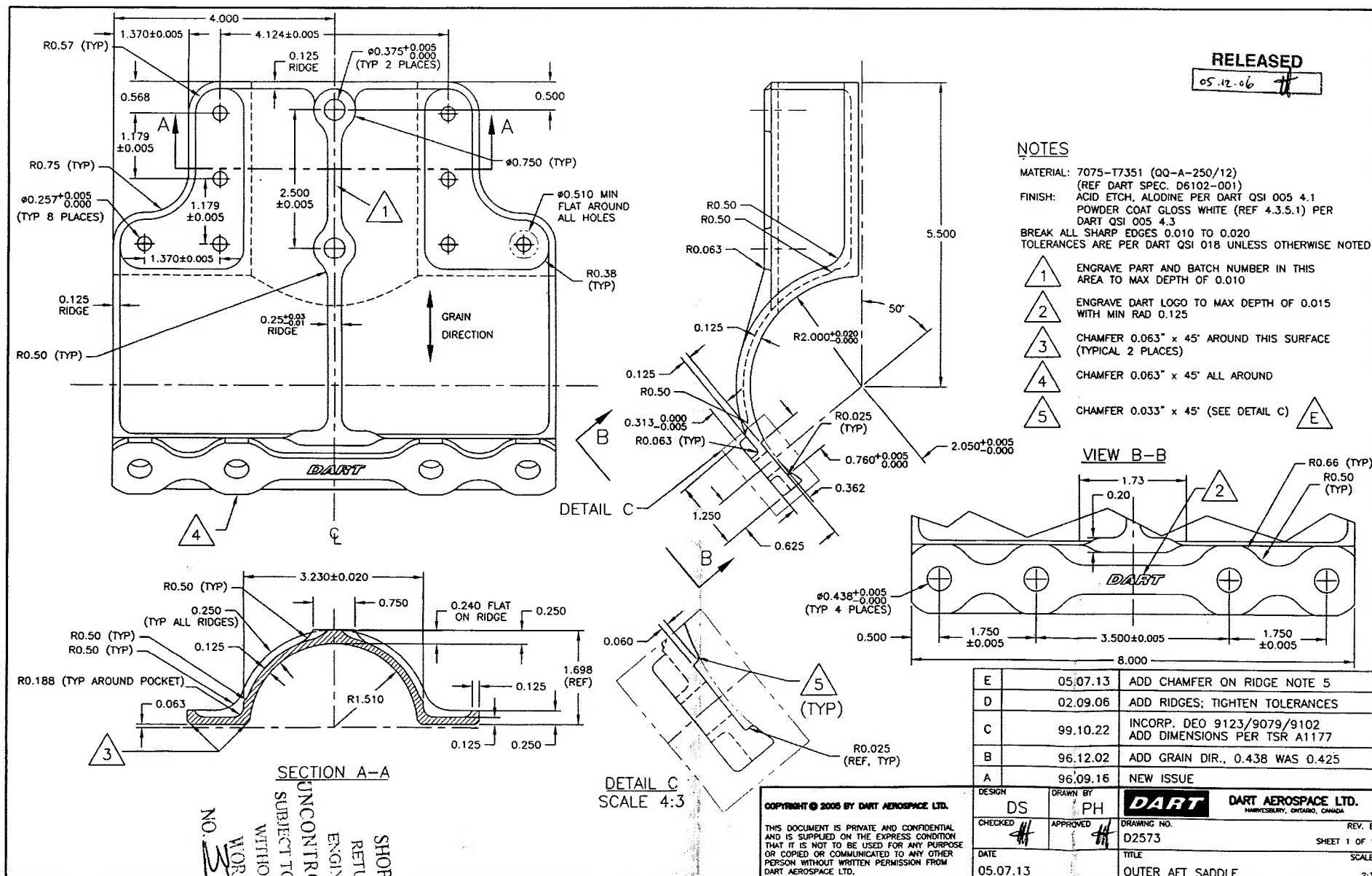
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G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.503	.503	.504	.503		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.570	.570	.572	.571		
L	1.174	1.184		1.175	1.175	1.175	1.175		
M	1.365	1.375		1.370	1.370	1.370	1.370		
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AG	0.240	0.280		.265	.265	.265	.265		
AH	0.240	0.260		.256	.256	.257	.254		
AI	2.000	2.020		2.003	2.001	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:   
Date: 08/03/18Audited by:   
Date: 08/03/21

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